



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3319-3
Job Sheet 171419



Part No: D3319-3

Job Qty: 12 ea

Part Name: Full Length Wearplate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/1/18

Job Tracking No:

Due Date: 2/2/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IPP: A 05.05.12 New issue KJ/JLM IPP Rev:B Now on Waterjet 06-10-03 JLM IPP REV:C 17.10.25 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	2/1/18	2/1/18	0.00	0.00	Start Up Waterjet		SC 18/02/18
100	Waterjet	6 pcs	2/1/18	2/1/18	0.00	1.40	Waterjet1		SC 18/02/18
110	QC	6 pcs	2/1/18	2/1/18	0.00	0.00	QC2 Waterjet-2		SC 18/02/18
120	QC	6 pcs	2/1/18	2/1/18	0.00	0.00	QC8-2		38
140	Brake NC	12 pcs	2/1/18	2/1/18	0.12	0.84	Brake NC 1		9-88 SB
150	QC	12 pcs	2/1/18	2/1/18	0.00	0.00	QC5		9B
160	Autoweld 1	12 pcs	2/1/18	2/1/18	0.00	3.82	Automated welding		R
170	QC	12 pcs	2/1/18	2/1/18	0.00	0.00	QC10		PD 18.3.7
180	QC	12 pcs	2/1/18	2/1/18	0.00	0.00	QC5		PD 18.3.7
190	Spray Paint	12 pcs	2/2/18	2/2/18	0.00	1.20	Spray Paint		✓ AB MAR 1 1 2018
200	QC	12 pcs	2/2/18	2/2/18	0.00	0.00	QC3		11 MAR 1 1 2018
210	Packaging	12 pcs	2/2/18	2/2/18	0.00	0.00	Packaging3-1	ST260B	9-89
220	QC21-SA	12 Ea	2/2/18	2/2/18	0.00	0.00	QC21		6 MAR 16 2018

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: D Prog Rev: D 2-Deburr if necessary

Descriptions: 140 - Form using DT8326 & DT8261 as per Dwg D3319

160 - 8259 Hardcoat Rod 138777

190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.

BATCH: 138819

210 - Identify on inside surface using a permanent fine point marker with the following:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	19.5000 sf (3.25 ea)	90-Start up Operation	

5042197 (45)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S18GA	20	76	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189	0.192	

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____	Step #: _____	Container No: S043530 Part: D3319-3 Job No: 171419 Serial No/Batch: S043530 Revision: D3319 Inspector: _____ Date: 02/18/18							
Description Work Order Deviation									
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:33%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> <td style="width:33%;"> Pressure/Fo ☐ Bending ☐ Centre Not C ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Fo ☐ Bending ☐ Centre Not C ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;"> Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%;"> Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:33%;"> Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>		Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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OTHER : _____		Completed By _____ _____ / Supervisor al Verification _____ Coordinator Approval							

2	Wearplate	0.500inches + 0.006 - 0.001	0.506 0.499	0,501
3	Wearplate	0.316inches ± 0.010	0.326 0.306	0,317
4	Wearplate	0.607inches ± 0.010	0.617 0.597	0,608
5	Wearplate	2.940inches ± 0.030	2.970 2.910	2,941
6	Wearplate	2.690inches ± 0.030	2.720 2.660	2,691
7	Wearplate	3.527inches ± 0.010	3.537 3.517	3,528
8	Wearplate	4.520inches ± 0.030	4.550 4.490	4,522
9	Wearplate	5.063inches ± 0.010	5.073 5.053	5,065
10	Wearplate	6.160inches ± 0.030	6.190 6.130	6,163
11	Wearplate	0.600inches ± 0.030	0.630 0.570	0,600
12	Wearplate	8.690inches ± 0.010	8.700 8.680	8,692
13	Wearplate	30.790inches ± 0.010	30.800 30.780	30,80
14	Wearplate	52.880inches ± 0.030	52.910 52.850	52,89
15	Wearplate	62.770inches ± 0.010	62.780 62.760	62,78
16	Wearplate	74.420inches ± 0.010	74.430 74.410	74,420
17	Wearplate	75.520inches ± 0.030	75.550 75.490	75,520
18	Wearplate	0.050inches ± 0.010	0.060 0.040	0,048

DQA: _____ Date: _____



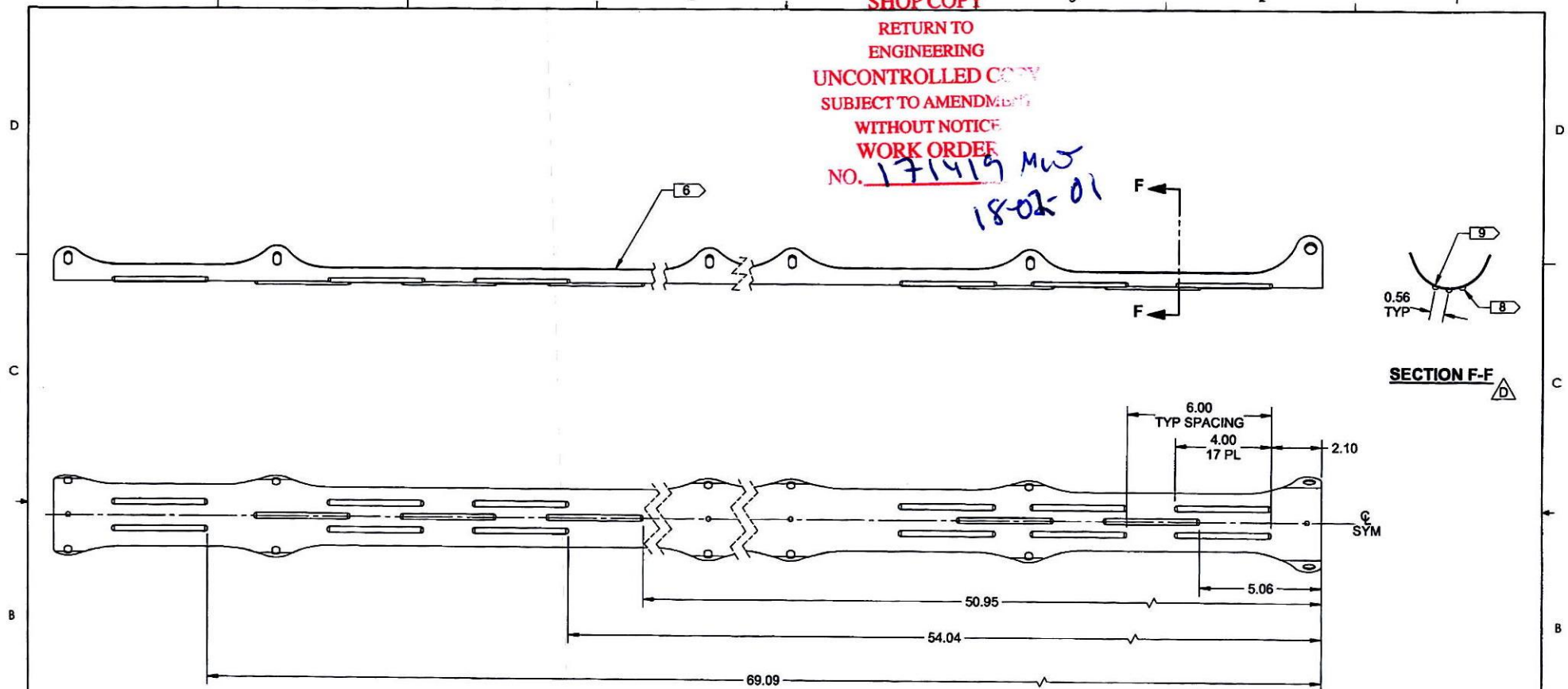
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENTS
 WITHOUT NOTICE
 WORK ORDER
 NO. 171419 MWS
18-02-01



SECTION F-F

D3319-3 WEARPLATE
 MAKE FROM D3319-3BND

RELEASED

2017 AUG 10

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3319-3" PER QSI 044 6.1
- 7) WEIGHT: 3.71 lbs
- 8) BUILDUP HARD SURFACE 0.06 TO 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILDUP HARD SURFACE 0.06 TO 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART QSI 005 4.9

APPROVED

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DP	D3319	SHEET 3 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DSS	WEARPLATE	NTS
DATE	17.05.09	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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DQA: _____ Date: _____

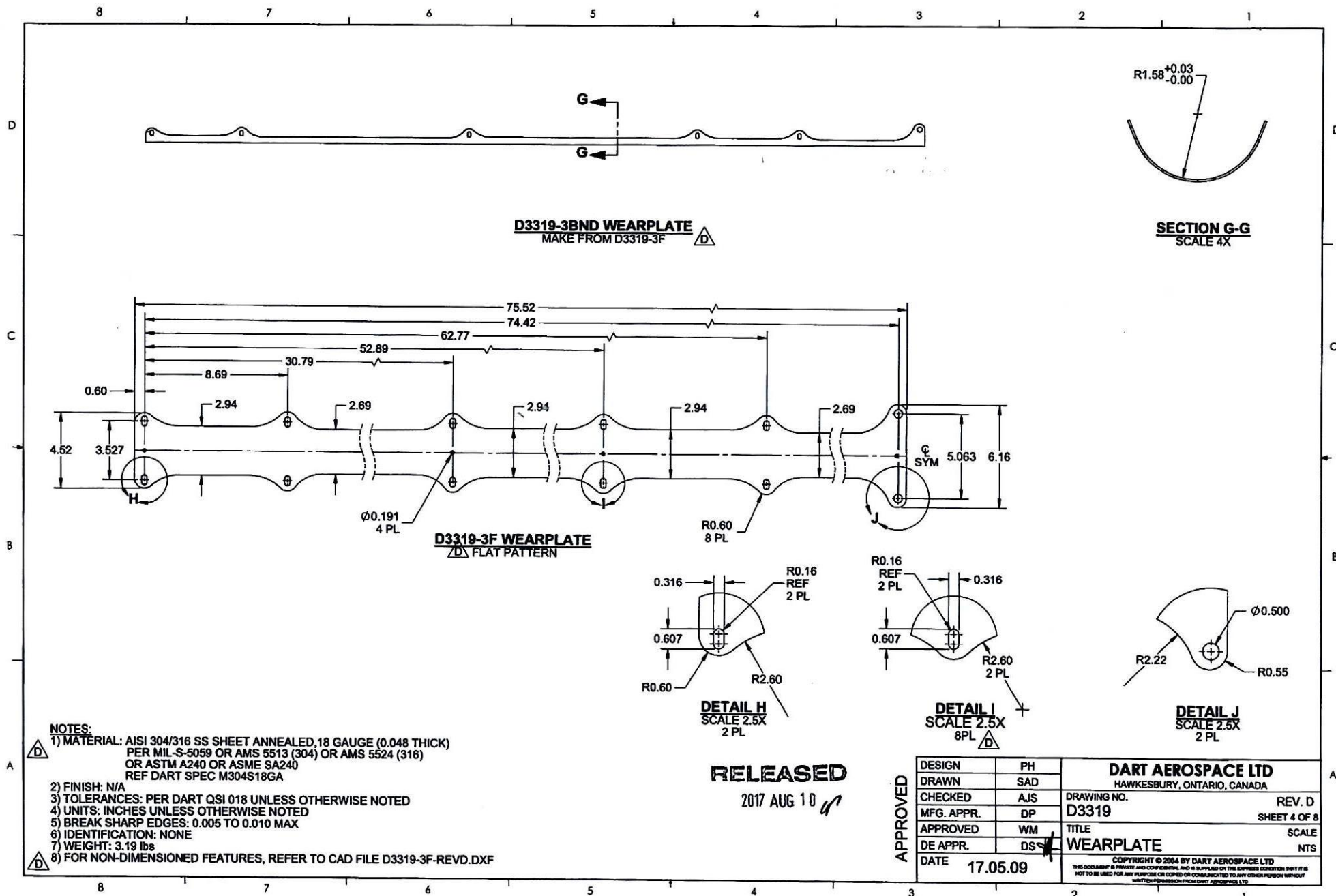
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OTHER : ☐						



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